

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016083**Date Inspected:** 08-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No			
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG				

**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance(QA) Inspector Mr.Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. The QA Inspector observed and/or found the following:

TRIAL ASSEMBLY YARD

ULTRASONIC TESTING

OBG SEGMENT 9AW-9BW

ABF Request No: 08062010-1

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the edge panel splice weld between OBG segment 9AW and 9BW on counter weight side. The Inspection was carried out on repair areas only. The weld designations were as follows:

OBW9-001 (OBG 9AW-9BW, E.P, CW side)

OBG SEGMENT 9EE

ABF Request No: 08062010-1

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## WELDING INSPECTION REPORT

( Continued Page 2 of 4 )

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This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the weld between deck panel and edge panel on cross beam side of OBG segment 9EE. The Inspection was carried out on repair areas only. The weld designations were as follows:

CA069-002 (OBG 9EE, D.P to E.P, CB side)

### OBG SEGMENT 9DE-9EE

ABF Request No: 08062010-1

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the weld between bottom panel and side panel on bike path side of OBG segment 9DE and 9EE. The Inspection was carried out on repair areas only. The weld designations were as follows:

SEG056-043 (OBG 9DE, S.P to B.P, BK side)

SEG058-014 (OBG 9EE, S.P to B.P, BK side)

### OBG SEGMENT 9BW-9CW

ABF Report No: UT-9W-051

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the edge panel splice weld between OBG segment 9BW and 9CW on counter weight side. The weld designations were as follows:

OBW9-006 (OBG 9BW-9CW, E.P, CW side)

### OBG SEGMENT 9BW-9CW

ABF Report No: UT-9W-052

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the edge panel splice weld between OBG segment 9BW and 9CW on cross beam side. The weld designations were as follows:

OBW9-010 (OBG 9BW-9CW, E.P, CB side)

### OBG SEGMENT 9BW-9CW

ABF Report No: UT-9W-053

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the

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## WELDING INSPECTION REPORT

( Continued Page 3 of 4 )

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inspection was identified as the bottom panel splice weld between OBG segment 9BW and 9CW. The weld designations were as follows:

OBW9B-008 (OBG 9BW-9CW, B.P)

### MAGNETIC PARTICLE TESTING

#### OBG SEGMENT 9AW-9BW

ABF Request No: 08062010-1

This QA Inspector witnessed ABF personal performing Magnetic Particle Testing (MT) on the edge panel splice weld between OBG segment 9AW and 9BW on counter weight side. The Inspection was carried out on repair areas only. The weld identification numbers were.

OBW9-001 (OBG 9AW-9BW, E.P, CW side)

No relevant indications were observed by this QA Inspector on this date.

#### OBG SEGMENT 9EE

ABF Request No: 08062010-1

This QA Inspector witnessed ABF personal performing Magnetic Particle Testing (MT) on the weld between deck panel and edge panel on cross beam side of OBG segment 9EE. The Inspection was carried out on repair areas only. The weld identification numbers were.

CA069-002 (OBG 9EE, D.P to E.P, CB side)

No relevant indications were observed by this QA Inspector on this date.

#### OBG SEGMENT 9DE-9EE

ABF Request No: 08062010-1

This QA Inspector witnessed ABF personal performing Magnetic Particle Testing (MT) on the weld between bottom panel and side panel on bike path side of OBG segment 9DE and 9EE. The Inspection was carried out on repair areas only. The weld identification numbers were.

SEG056-043 (OBG 9DE, S.P to B.P, BK side)

SEG058-014 (OBG 9EE, S.P to B.P, BK side)

No relevant indications were observed by this QA Inspector on this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No significant conversations were reported on this date.

### Comments

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## WELDING INSPECTION REPORT

( Continued Page 4 of 4 )

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Utekar,Shrikant

Quality Assurance Inspector

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**Reviewed By:** Peterson,Art

QA Reviewer